



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3078-041
Job Sheet 212212



Part No: D3078-041

Job Qty: 1 pcs

Part Name: Step Assembly, Hi Short LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/20

Job Tracking No:

Due Date: 8/21/20

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 15.11.12 NEW ISSUE DD VERF:JLM IPP REV:B 16.03.15 DWG REV.B DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	1 pcs			0.00	1.00	Large Fab - 1		AUG 18 2020
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4	DAS	
							Large Fab - 5	24	
							Large Fab - 6	9-89	
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
120	QC 5	1 pcs			0.00	0.00	QC 5 - 10		28-18-20
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		



Container No: S294634



Part: D3078-041

Job No: 212212

Serial No/Batch: S294634

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/18/20

Plex 8/13/20 1:57 PM dart.leroux.jason

130 Large Fab - Welded Assy-2-B4B	1 pcs	0.00 1.30	QC 5 - 81	
			QC 5 - 82	
			Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
140 QC 9	1 pcs	0.00 0.00	QC 9 - 10	
			QC 9 - 18	
			QC 9 - 24	
			QC 9 - 43	
			QC 9 - 50	
			QC 9 - 9	
150 QC 5	1 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
160 Handfinish - 1-1 Chemical-B4B	1 pcs	0.00 0.12	Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	

DAS
24
9-89

AUG 18 2020

Q 8-18-20

Q 8-18-20

			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
170 QC 7	1 pcs	0.00 0.00	QC 7 - 10	JLT 2020/08/19
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
			QC 7 - 87	
200 Large Fab - Welded Assy-3-B4B	1 pcs	0.00 1.01	Large Fab - 1 - B4B	DAS 24 9-89 AUG 20 2020
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
210 QC 10	1 pcs	0.00 0.00	QC 10 - 10	D 20-8-21
			QC 10 - 18	
			QC 10 - 24	
			QC 10 - 43	
			QC 10 - 50	
			QC 10 - 58	
			QC 10 - 9	

220 QC 5	1 pcs	0.00 0.00	QC 10 - 68	
			QC 10 - 81	
			QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	20-8-24
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
240 Handfinish - 6-1- Touch Up- B4B	1 pcs	0.00 0.12	Handfinish - 6 - 1 - B4B	20-08-25
			Handfinish - 6 - 2 - B4B	
			Handfinish - 6 - 3 - B4B	
			Handfinish - 6 - 4 - B4B	
			Handfinish - 6 - 5 - B4B	
			Handfinish - 6 - 6 - B4B	
			Handfinish - 6 - 7 - B4B	
			Handfinish - 6 - 8 - B4B	
			Handfinish - 6 - 9 - B4B	
			Handfinish - 6 - 10 - B4B	
			Handfinish - 6 - 11 - B4B	
			Handfinish - 6 - 12 - B4B	
			Handfinish - 6 - 13 - B4B	
			Handfinish - 6 - 14 - B4B	
			Handfinish - 6 - 15 - B4B	
			Handfinish - 6 - 16 - B4B	
			Handfinish - 6 - 17 - B4B	
			Handfinish - 6 - 18 - B4B	
			Handfinish - 6 - 19 - B4B	
			Handfinish - 6 - 20 - B4B	
			Handfinish - 6 - 21 - B4B	
			Handfinish - 6 - 22 - B4B	
250 Powdercoat - 1 White Gl(A)- B4B	1 pcs	0.00 0.23	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	20-08-26
			Powdercoat - 4 - B4B	
			Powdercoat - 5 - B4B	
			Powdercoat - 6 - B4B	
			Powdercoat - 7 - B4B	
			Powdercoat - 8 - B4B	
			Powdercoat - 9 - B4B	
			Powdercoat - 10 - B4B	
260 Handfinish - 3-1- WingWalk- B4B	1 pcs	0.00 0.12	Handfinish - 3 - 1 - B4B	20-8-27
			Handfinish - 3 - 2 - B4B	
			Handfinish - 3 - 3 - B4B	
			Handfinish - 3 - 4 - B4B	
			Handfinish - 3 - 5 - B4B	

270 QC 3

1
pcs

0.00 0.00

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 68

QC 3 - 9

QC 3 - 40

QC 3 - 19

QC 3 - 43

QC 3 - 24

QC 3 - 61

QC 3 - 81

QC 3 - 82

QC 3 - 87

QC 3 - 47

DAS
82
9-89

AUG 31 2020

290 Packaging 3-1 - Stock - B4B

1
pcs

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

DAS
69
9-89

SEP 02 2020

300 QC 21 - SA	1 pcs	0.00 0.00	Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
			QC 21 - SA - 21	
			QC 21 - SA - 70	SEP 02 2020 DAS
			QC 21 - SA - 9	70
			QC 21 - SA - 77	9-89

Part Op 110 - (Fabricate per Drwg) 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg Descriptions: D3078 using Jig DT8680 for rivets. 3-Debur & buff scratches

120 - QC5- Inspect part completeness to step on W/O

130 - (Weld per dwg A/R Aluminum rod Batch: 139019 1-Bevel end for welding FWD ONLY 2-Weld Support, weld Fwd End Plate as per QSI 004 & Dwg D3072 A/R Aluminum Rod 139019 3-Grind End Plate flush

140 - (QC9- Inspect visual per QSI004- Fusion Welds)

150 - QC5- Inspect part completeness to step on W/O)

160 - (Chemical Conversion Coat per QSI005 4.1)

170 - (QC7-Inspect Chemical Conversion Coat)

200 - (Weld per dwg A/R Aluminum rod Batch: 139019 Rivet Leg Assembly as per Dwg D3078. 2-Bevel Aft end for welding 3-Inspect for foreign object as per QSI 024 4-Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod 139019 5-Grind End Plate flush

210 - (QC10- Inspect visual per QSI004- ground welds)

220 - (QC5- Inspect part completeness to step on W/O)

240 - (Touch up alodine)

250 - (White Gloss (Ref: 4.3.5.1) per QSI005 4.3-Alum) START TIME 10:15 OVEN TEMPERATURE: 320°

FINISH TIME: 12:45

260 - (Wing Walk as per dwg QSI005 4.4 Batch _____)

270 - (QC3- Inspect Part Finish)

290 - (Identify as per dwg & Stock Location: _____)

300 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	.5000 pcs (.5 ea)	110-Large Fab - Welded Assy-1	<u>5269728</u>
D3067-1	End Plate	2 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	<u>5267468</u>
D3219-3	Plate	2 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	<u>5229367</u>
D3065-041	Step Leg Assembly	1 pcs (1 ea)	200-Large Fab - Welded Assy-3- B4B	<u>5292376</u>
D3066-1	Spacer	2 pcs (2 ea)	200-Large Fab - Welded Assy-3- B4B	<u>5264205</u>
MS20600-AD4W4	Rivet	16 Ea (16 ea)	200-Large Fab - Welded Assy-3- B4B	<u>5251801</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D2622-120C	1	225	0
130-Large Fab - Welded Assy-2- B4B	D3067-1	2	146	0
	D3219-3	2	66	0
200-Large Fab - Welded Assy-3- B4B	D3065-041	1	13	0
	D3066-1	2	143	0
	MS20600-AD4W4	16	1,153	0

Part Specifications

Specifications could not be found.

Plex 8/13/20 1:57 PM dart.leroux,jason